DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029013
Date Inspected: 17-Jan-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

CWI Name:	As noted below.			**CWI Present:**	☑ Yes	☐ No		
Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A	
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A	
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A	
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A	

Bridge No: 34-0006
Component: Tower

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Ultrasonic Testing of ESW
ESW F, Face B:

This QA performed Ultrasonic Testing (UT) on approximately 500mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as “ESW F” face B. Location (Y=7000~7500) of this weld was inspected using this testing method.

At the request of QA Level III Robert Mertz, ABF personnel , and Quality Control personnel this QA performed information only UT. The goal of this testing was to ascertain whether UT could be used to observe the planar characteristics of indications previously discovered at this location. This QA used the 6db drop amplitude method to record the depths of the top and bottom of these previously discovered indications.

The findings were recorded as follows:

Location #1
Y= 7435mm
B- SP=86mm, DP= 30mm
B1- SP= 72mm, DP= 25mm

B2- SP= 117mm, DP= 41mm

Location #2
Y= 7385mm
B- SP=124mm, DP= 43mm
B1- SP= 104mm, DP= 36mm
B2- SP= 141mm, DP= 50mm

Location #3
Y= 7150mm
B- SP=103mm, DP= 36mm
B1- SP= 56mm, DP= 20mm
B2- SP= 148mm, DP= 52mm

Location #4
Y= 7065mm
B- SP=127mm, DP= 45mm
B1- SP= 114mm, DP= 40mm
B2- SP= 136mm, DP= 48mm

B1 represents the “top”, or shallowest recorded depth of the indication.
B2 represents the “bottom”, or deepest recorded depth of the indication.

This QA has not generated a TL-6027 UT report on this date. Findings have not been joint verified by Quality Control inspection personnel at this time.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversation was relevant to testing performed during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer